

Work Order ID 65821

Wednesday, January 26, 2011 11:10:09 AM



Page 1

Item ID: D206-547-043

Accept



Setup Start



Revision ID:

Item Name: Console High Slope

Stop



Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-01-26 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-547	Rev F

100
 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab 1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4 2-Debur

[Signature] 11/02/04 4RH 42H

110
 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab 1-Grind weld relief chamfer as per Dwg D206-547 2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

[Signature] 11/02/04 4RH 42H

120
 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

44 LH
 4RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Large Fab

Large Fab

Memo

0.00

0.00

Large Fab

1-Tack weld as per Dwg D206-547 A/R
Batch: M108436

AL ROD

11.02.15

*4 LH
4 RH*

φ

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Subosko

*x4 LH
x4 RH*

150



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

Memo

0.00

0.00

Subosko

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 3

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Item Name: Console High Slope

Start Date: 1/26/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

Handwritten signature 11/02/16 *Handwritten initials*

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten: S 11/02/16

Handwritten: 74

180

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Handwritten: M112588

Memo

0.00

Powder Coating

START TIME: *9:00* OVEN TEMPERATURE:

320 FINISH TIME: *9:50*

Handwritten: H. BL 11-02-18.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 4

Wednesday, January 26, 2011 11:10:10 AM

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Stop



Item Name: Console High Slope

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 of 11/02/18

200

Identify as per dwg & Stock Location: _____ 0.00



Packaging

Memo

0.00

Packaging

PPP657444

11/02/18 (Y)

210

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/02/22

MF
11-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:10:15 AM

Page 1

Work Order ID: 65821

Parent Item: D206-547-043

Parent Item Name: Console High Slope



Start Date: 1/26/2011

Start Qty: 4.00

Required Date: 2/7/2011

Required Qty: 4.00

Comments: IPP Rev: I 06-01-05 Removed Packing Kit JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20470AD3-4 Rivet, Universal Head		Purchased	No			100	Each	10,550.00	20	80			
<div> <div>Location</div> <div>ST319</div> <div>111477</div> <div>15541</div> </div> <div> <div>Loc Qty</div> <div>10550</div> <div>8332</div> <div>2218</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2024 Console Extrusion		Manufactured	No			110	f	1,139.800	3.42	14.4			
<div> <div>Location</div> <div>MAT06</div> <div>1</div> </div> <div> <div>Loc Qty</div> <div>1139.8</div> <div>1139.8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2602-1 Console Side, 206 Console		Manufactured	No			110	Each	5.0000	1	4			
<div> <div>Location</div> <div>ST178</div> <div>60300</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2602-2 Console Side, 206 Console		Manufactured	No			110	Each	7.0000	1	4			
<div> <div>Location</div> <div>ST177</div> <div>52697</div> <div>ST178</div> <div>60301</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													

Handwritten signatures and dates:
 1/26/04
 80
 14.4
 4
 4
 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:10:15 AM

Page 2

Work Order ID: 65821

Parent Item: D206-547-043

Parent Item Name: Console High Slope

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

D2606

Manufactured No

110 Each

16.0000

1

4



Console Bracket, 206/407 Console

Location

Loc Qty

Loc Code

ST020

16

53196

16

D2607

Manufactured No

110 Each

12.0000

1

4



Bracket, 206 Console

Location

Loc Qty

Loc Code

ST020

12

58208

12

MS20470AD3-3

Purchased No

110 Each

8,411.000

8

32



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

8411

1065

1435

16941

6976

32

Wednesday, January 26, 2011 11:10:15 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

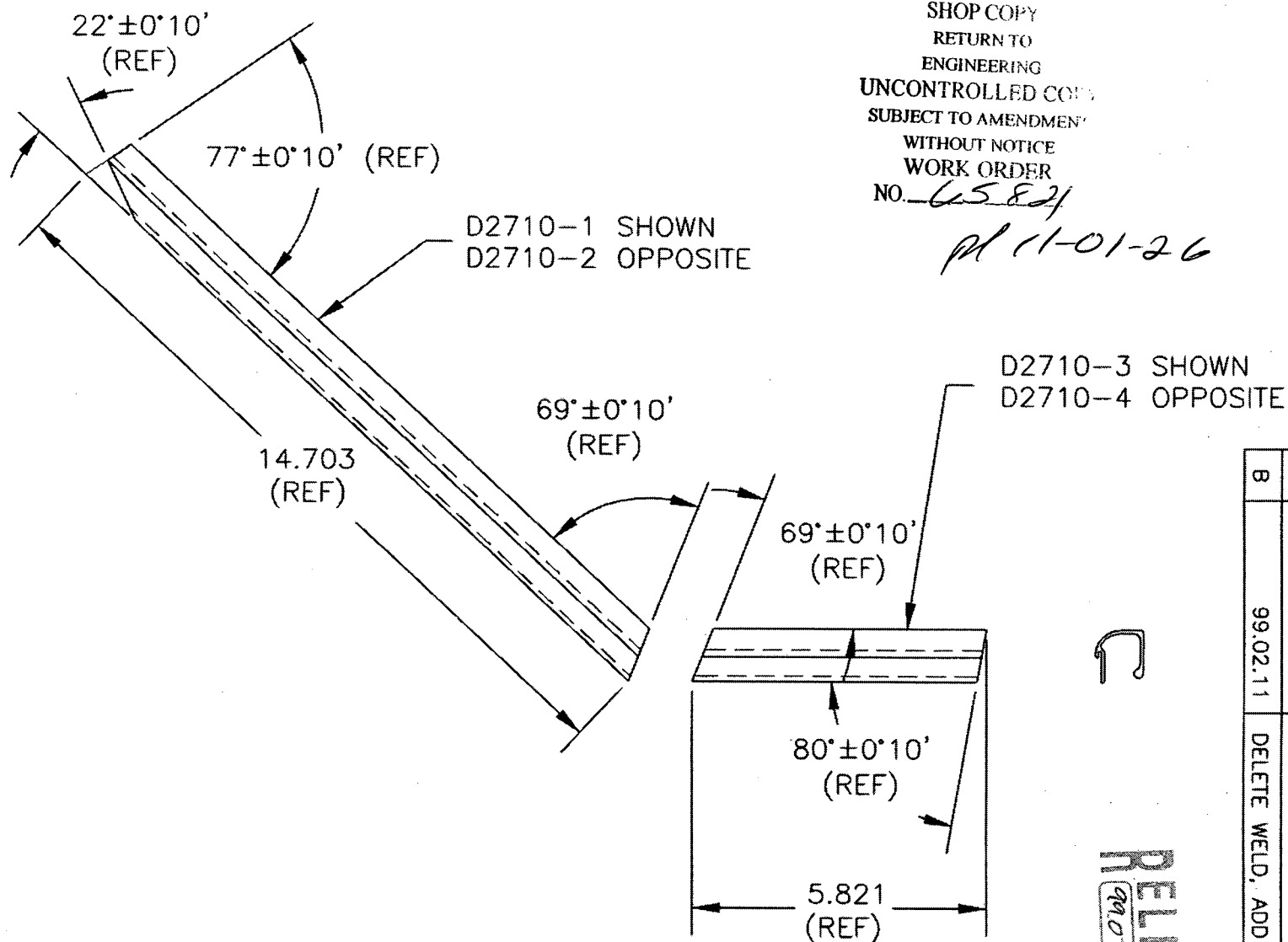
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 65821

pl 11-01-26



DESIGN	DRAWN BY	TITLE	REV. B
BW	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
<i>CP</i>	<i>KE</i>	D2710	
DATE		SCALE	
99.02.11		1:3	
A	B		
97.10.25	99.02.11	NEW ISSUE	
		DELETE WELD, ADD TEMPL. (TSR A1020)	

RELEASED
 990705 KE

MATERIAL: MAKE FROM D2024 EXTRUSION
 MAKE PER TEMPLATE # DT8264
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.8.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043, -045, -047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

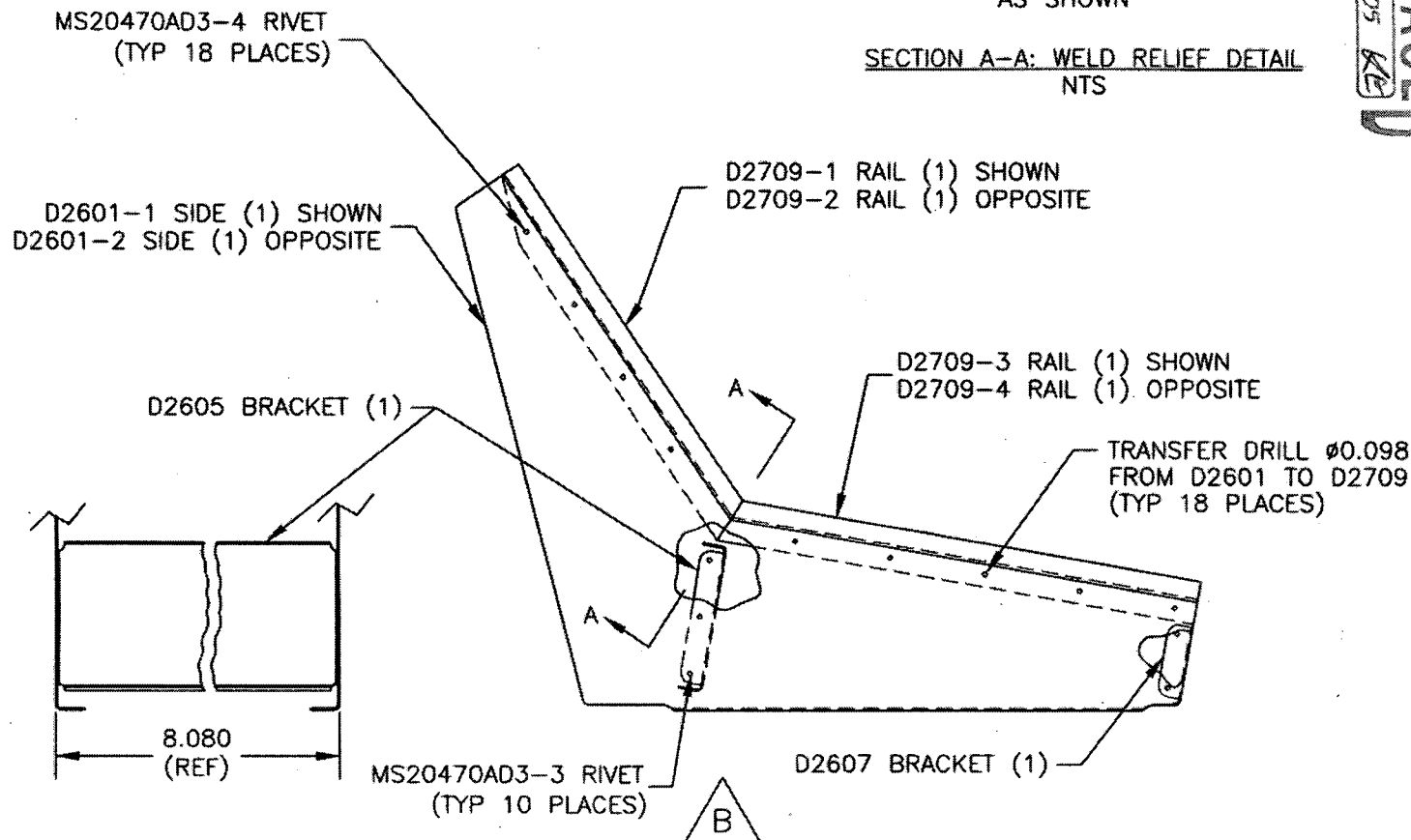
DART

RELEASED
M.0705 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	JP	APPROVED	KE	DRAWING NO. D206-547
DATE	99.02.11	TITLE	CONSOLE ASSEMBLY	SHEET 2 OF 5
		SCALE	1:4	REV. F

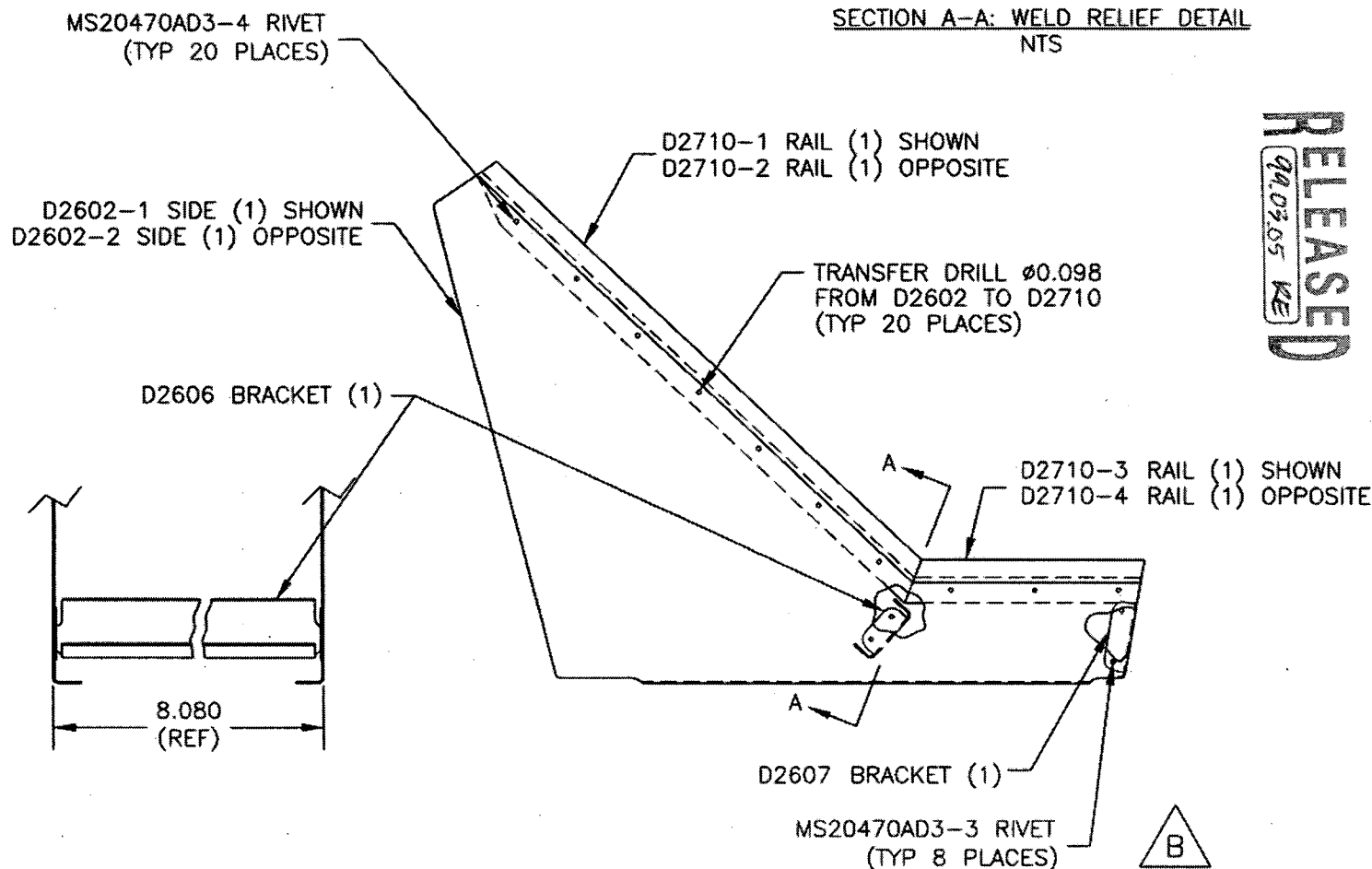
DART

RELEASED
940305 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

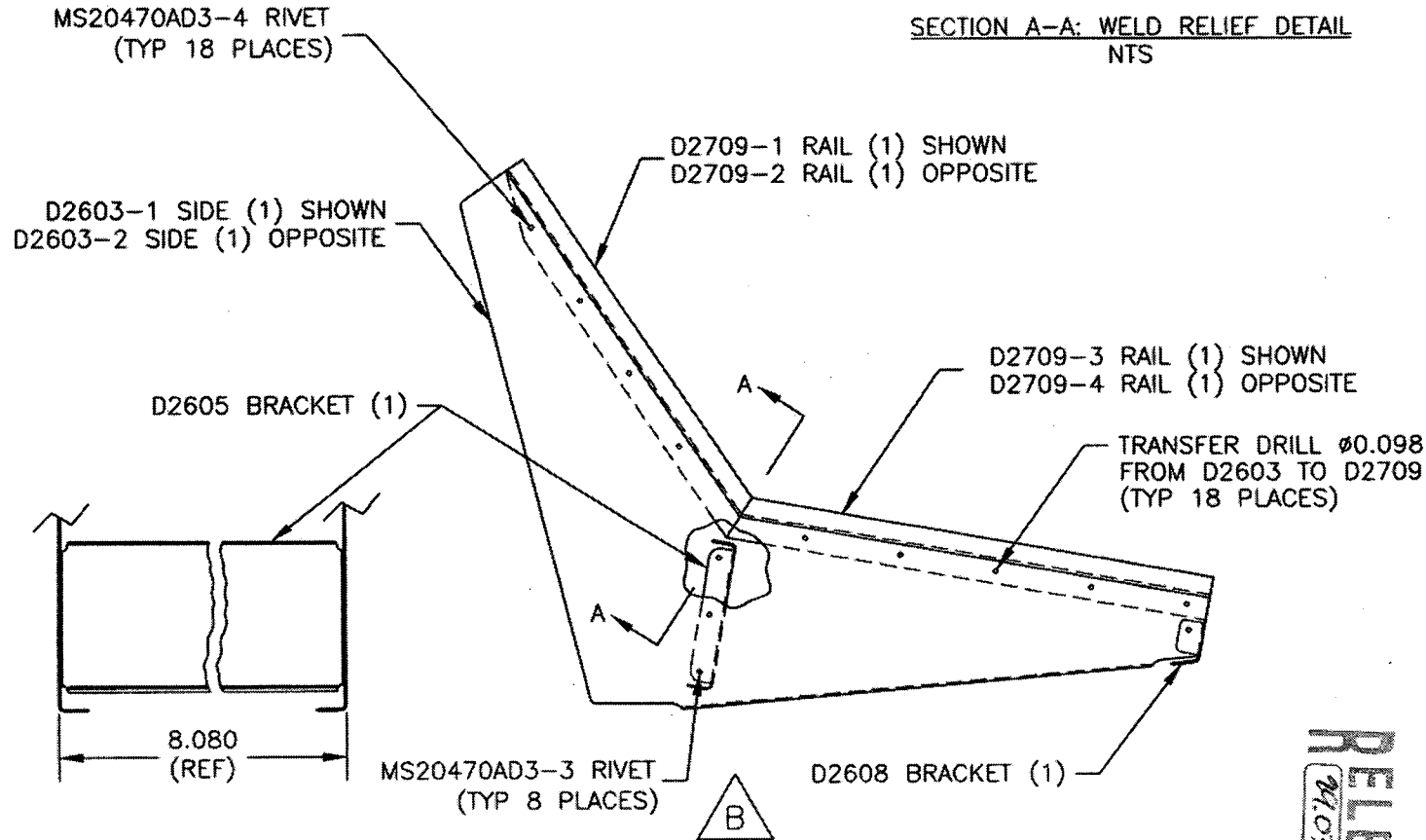
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
UP	KE	D206-547
DATE	TITLE	SHEET 3 OF 5
99.02.11	CONSOLE ASSEMBLY	REV. F
		SCALE
		1:4

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
210305 RE

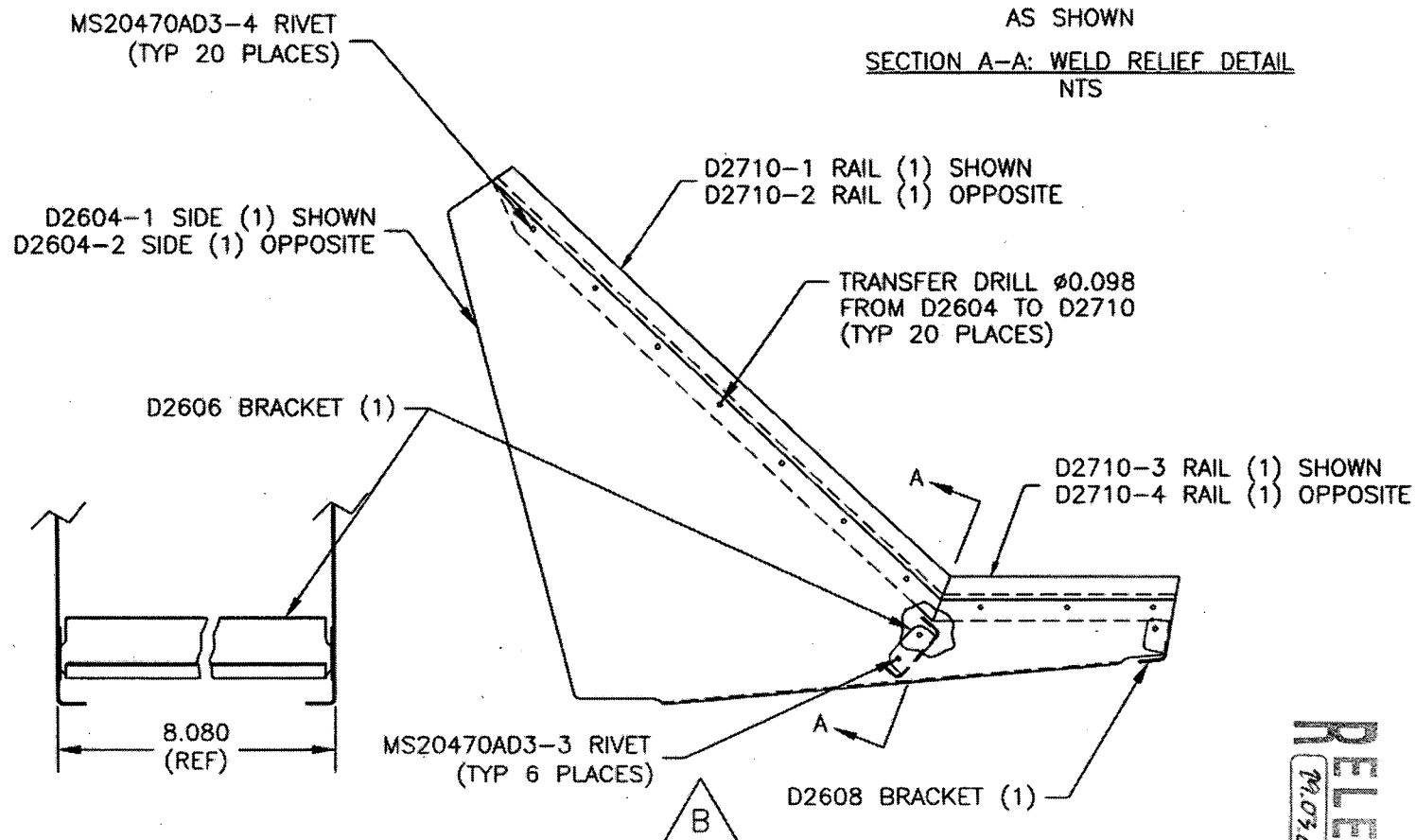
DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED JP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 4 OF 5
		SCALE 1:4

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
M.03.05 KE

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	
DATE	99.02.11	DRAWING NO.	D206-547	SHEET 5 OF 5
		TITLE	CONSOLE ASSEMBLY	SCALE 1:4